

Work Order ID 92879

92879

Page 1

Friday, November 09, 2012 1:00:58 PM

Item ID: D4093-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 11/9/2012 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 11/16/2012 Req'd Qty: 7.00 ***7*** Customer:
 Reference: REWORK PER ECN 12-660

Approvals: Process Plan: UMF Date: 12-11-09 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4093	D

190 0.00 ***190*** 12-11-13

Mill Conv Memo
 Conventional Milling Machine PULL FROM STOCK D4093-1 X 7:
 1 X B82766
 6 X B85941
 REWORK TO NEW DRAWING REV D
 (ADD HOLE)

200 0.00 ***200*** QC5- Inspect part completeness to step on W/O
 QC Memo 12-11-13

7

7

Work Order ID 92879

Friday, November 09, 2012 1:00:58 PM

92879

Page 2

Item ID: D4093-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 11/9/2012 Start Qty: 7.00 ***7***

Cust Item ID:

Required Date: 11/16/2012 Req'd Qty: 7.00 ***7***

Customer:

Reference: REWORK PER ECN 12-660

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

TOUCH UP WITH ALODINE ON REWORKED AREA

7 26 12-11-13

220

QC7-Inspect Chemical Conversion Coat

0.00

220

QC

Memo

0.00

Quality Control

15
12-11-14

7

230

Identify as per dwg & Stock Location: 81487 0.00

230

Packaging

Memo

0.00

Packaging

7x

Sp
12-11-14

Work Order ID 92879***92879***

Page 3

Friday, November 09, 2012 1:00:58 PM

Item ID: D4093-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***Start Date: 11/9/2012 Start Qty: 7.00 ***7***

Cust Item ID:

Required Date: 11/16/2012 Req'd Qty: 7.00 ***7***

Customer:

Reference: REWORK PER ECN 12-660

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

12/11/15 *[Signature]*

W12-11.14

Picklist Print

Friday, November 09, 2012 1:00:57 PM

Page 1

Work Order ID: 92879

Parent Item: D4093-1

Parent Item Name: Bracket

Start Date: 11/9/2012

Required Date: 11/16/2012

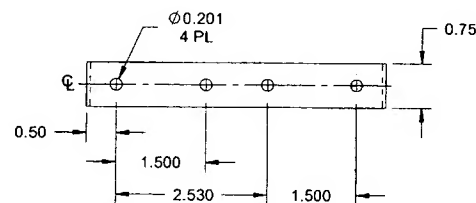
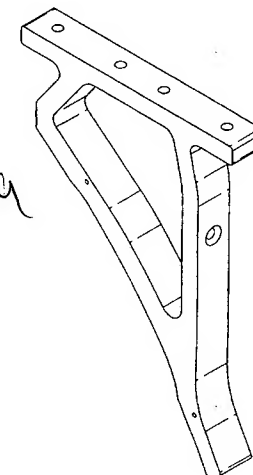
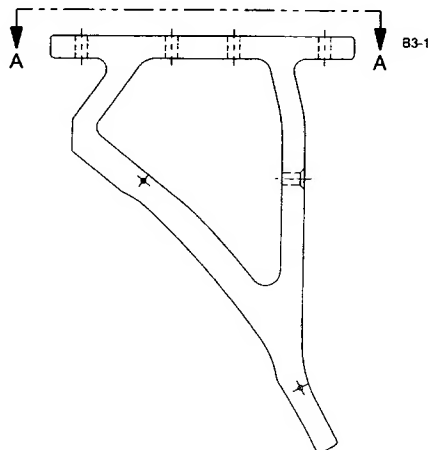
Start Qty: 7.00

Required Qty: 7.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD IPP REV:B AS PER REV C
11.09.28 JLM VERIFIED BY:DD IPP REV:C 12.10.31 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4093-1 Bracket		Manufactured	No				Each	0.0000		7			

1 x 82766 } mk
6 x 85941 }
12-11-09
12-11-13
ST 145
200



SECTION VIEW A-A D6-1

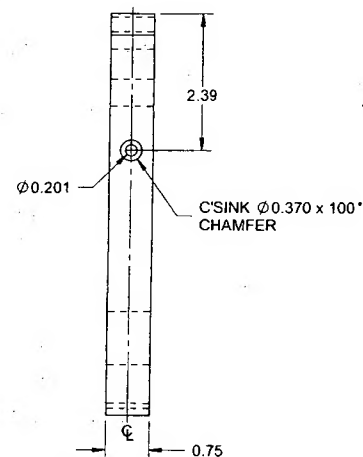
RELEASED
2012-10-3

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs

D4093-1 BRACKET

D	ADD Ø0.080 HOLES (ZN B5-2, B5-4)	RF	12.09.18
C	REDRAWN D4093-1/3 (ZN B4-1, B4-2); ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
B	REDRAWN D4093-1/3 (ZN B4-1, B4-2)	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	D4093	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
DATE	12.09.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



#92879

RELEASE
2012-10-3 10

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4093	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	12.09.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED AS THE PROPERTY OF THE COMPANY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	